

32

Work Order ID 50211

July 14, 2009 2:46:38 PM



Page 1

Item ID: D2935

Accept



Setup

Start



Revision ID: B

Stop



Item Name: Saddle Spacer

Start Date: 7/15/09 Start Qty: 30.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 30.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 09-07-15 Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D2935 | Rev B |

100 0.00

| | |
|--|----------------|
| | FLOW WATER JET |
|--|----------------|

Waterjet 0.00

FLOW CNC Waterjet Memo 1-Cut as per Dwg D2935

Dwg Rev: BProg Rev: B

2-Deburr if necessary

IR 9-8-4

→ Deburr m-f 09/08/06

72X

110 0.00

| | |
|--|---|
| | QC2- Inspect parts off machine FAI/FAIB |
|--|---|

QC 0.00

Quality Control

IR 9-8-4

120 0.00

| | |
|--|-----------------------------------|
| | QC8- Inspect parts - second check |
|--|-----------------------------------|

QC 0.00

Quality Control

→ So 09/08/04

cont'd
472

f

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 50211

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July 14, 2009 2:46:38 PM

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Accept



Setup Start



Revision ID: B

Stop



Item Name: Saddle Spacer

Start Date: 7/15/09 Start Qty: 30.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

⇒ 10 09-08-10 X72

0.00

Hand Finishing

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

⇒ ∑ 09/08/10

Counted

0.00

Memo

X72

/

150



Packaging

Packaging

Identify as per dwg & Stock Location SS

0.00

9/8/11

Memo

0.00

72x SP

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Work Order ID 50211

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July 14, 2009 2:46:38 PM

Item ID: D2935

Accept



Setup Start



Revision ID: B

Stop



Item Name: Saddle Spacer

Start Date: 7/15/09 Start Qty: 30.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 30.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID**

160



QC

Quality Control

**Operation
Description**

QC21- Final Inspection - Work Order Release

**Set Up/
Run Hours**

0.00

**Draw
Number****Draw
Rev.****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

Memo

0.00

09/08/26 HJ

H 09-08-06

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Page 1

July 14, 2009 2:46:37 PM

Work Order ID: 50211



Parent Item: D2935RevB



Parent Item Name: Saddle Spacer

Start Date: 7/15/09

Required Date: 7/15/09

Comments:

Start Qty: 30.00

Required Qty: 30.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M6061T6S.080 | | Purchased | No | | 100 | | sf | 190.9800 | 1.6011 | | | |

6061-T6 .080 Sheet



| <u>Warehouse</u> <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-------------------------------------|----------------|-----------------|
| Main Warehouse | | |
| MAT | 190.98 | |
| 107272 | 1.25 | |
| 110254 | 2.5 | |
| 110630 | 43.23 | |
| 112040 | 80 | |
| 112141 | 64 | |

111003

111003 1, HB 9-8-5

(72)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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|----------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | SD211 |
| Description: Saddle Spacer | Part Number: | D2935 |
| Inspection Dwg: D2935 | Rev: B | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

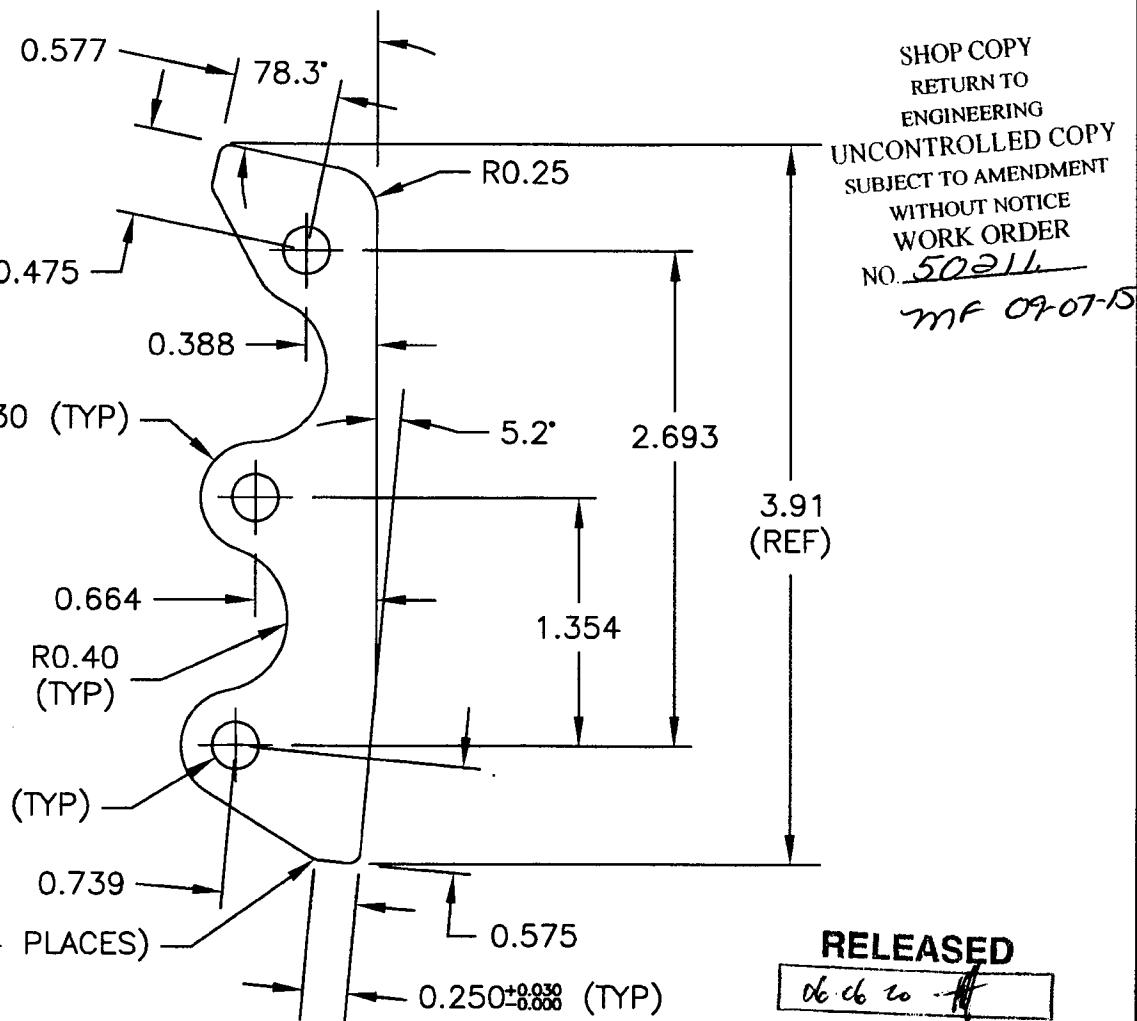
X First Article Prototype

| | | | | | |
|--------------|-----------|-------------|----------|---------------------|-----|
| Measured by: | <u>BR</u> | Audited by: | <u>S</u> | Prototype Approval: | N/A |
| Date: | 9-8-4 | Date: | CS/08/04 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|------------------|------------|----------|
| A | 06.06.05 | New Issue | KJ/JLM | |
| B | 06.06.23 | Dwg Rev. changed | KJ/JLM | JL |

DART

| | | | |
|----------------------|--------------------------------|--|------------------------|
| DESIGN <i>FF</i> | DRAWN BY <i>CB</i> | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED <i>PH</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2935 | REV. B SHEET 1 OF 1 |
| DATE 06.05.29 | | TITLE SADDLE SPACER | SCALE 1:1 |
| A | 99.11.02 | NEW ISSUE | |
| B | 06.05.29 | ADD 6061-T6 MATERIAL | |

**NOTES:**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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